# Work Order ID 120780

*Wednesday, June 11, 2014 10:32:38 AM*

*120780*



**Item ID:** D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Fwd, Center Ceiling Panel

**Start Date:** 6/11/14 **Start Qty:** 1.00 *1*

**Required Date:** 6/11/14 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** M _____ **Date:** 14-6-11 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** / **Revision Nbr**: D4634 / F | | | | | | | | | |
| 100 | | 0.00 | | | | | | | DAS 07 9-89 |
| *100* | HAND FINISHING THERMOFORMING | | | | | Y/ | | | |
| Thermoform | **Memo** | 0.00 | | | | | | | |
| Thermoforming Machine | Cut Blanks | | | | | | | | 14/06/16 |
| 105 | | 0.00 | | | | | | | DAS 07 9-89 |
| *105* | Dry Material | | | | | X/ | | | |
| HandThermo | **Memo** | 0.00 | | | | | | | |
| Hand Finishing Thermoforming | Dry Sheet as per QSI022 POLYCARBONATE | | | | | | | | 14/06/16 |

Temp: 245 deg. F JUN 16 2014

Time IN: 5:00 PM

Time OUT: 6:00 AM Per.....

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

**Item ID:** D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Fwd, Center Ceiling Panel
**Start Date:** 6/11/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
**Required Date:** 6/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 110 | | 0.00 | | | | | | | DAS 07 9-89 |
| *110* | THERMOFORMING MACHINE | | | | | x1 | | | |
| Thermoform | **Memo** | 0.00 | | | | | | | |
| Thermoforming Machine | Thermoform as per Dwg. D4634-1 and Folio FTA144 | | | | | | | | 14/06/16 |
| | Dwg. Rev. F | | | | | | | | |
| | Folio Rev. E | | | | | | | | |
| | NOTE: Check moulds prior to using to ensure proper placement of add-ons. | | | | | | | | |
| | Visually inspect for proper formation and texture | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | HAND FINISHING THERMOFORMING | | | | | x1 | | | BB 14/07/10 |
| Thermoform | **Memo** | 0.00 | | | | | | | |
| Thermoforming Machine | Trim to Finished Dimensions | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

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- ☐ Bending
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- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
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- ☐ Cut Too Short
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
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- ☐ Set-up
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- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Work Order ID 120780

*Wednesday, June 11, 2014 10:32:38 AM*

*120780*

**Item ID:** D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Fwd, Center Ceiling Panel

**Start Date:** 6/11/14 **Start Qty:** 1.00 *1*

**Required Date:** 6/11/14 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 140 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *140* | Dimensional Inspection | | | | | 1 | | | BB 14/07/23 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | Fill in Inspection Sheet Rev A | | | | | | | | |
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 DAS 27 9-89 | | | | | | | |
| *150* | | | | | | 1 | | | |
| QC | **Memo** | 0.00 14/7/23 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | | 0.00 | | | | | | | |
| *160* | Packaging | | | | | (1) | SAD | 14/07/23 | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Section MF | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

# Picklist Print



*Wednesday, June 11, 2014 10:32:38 AM*

**Work Order ID:** 120780 *120780*

**Parent Item:** D4634-1 *D4634-1*

**Parent Item Name:** Fwd, Center Ceiling Panel

**Start Date:** 6/11/14 **Required Date:** 6/11/14

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:** IPP Rev.A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg Update, Material Change 13/12/18 DL IPP Rev D Dwg Update Change Mtl Qty. 14/01/20 DL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| MLEXS.093-F6006-07 | | Purchased | No | | | 100 | sf | 1,148.443 | 17.3 | 18 | | | DAS 07 9-89 |
| *MLEXS.093-F6006-07* | | | | | | | | | ** | | | | |

GE PLASTICS LEXAN SHEET (Grey)

14/06/17

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT023 | 1148.44332 | | |
| 114459 | 229.26 | | |
| 123105 | 38 | | |
| 124501 | 543.5 | | |
| m128668 | 181.35 | | |
| m129014 | 156.33332 | | |
| M129471 | | | 18 sq ft |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
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**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

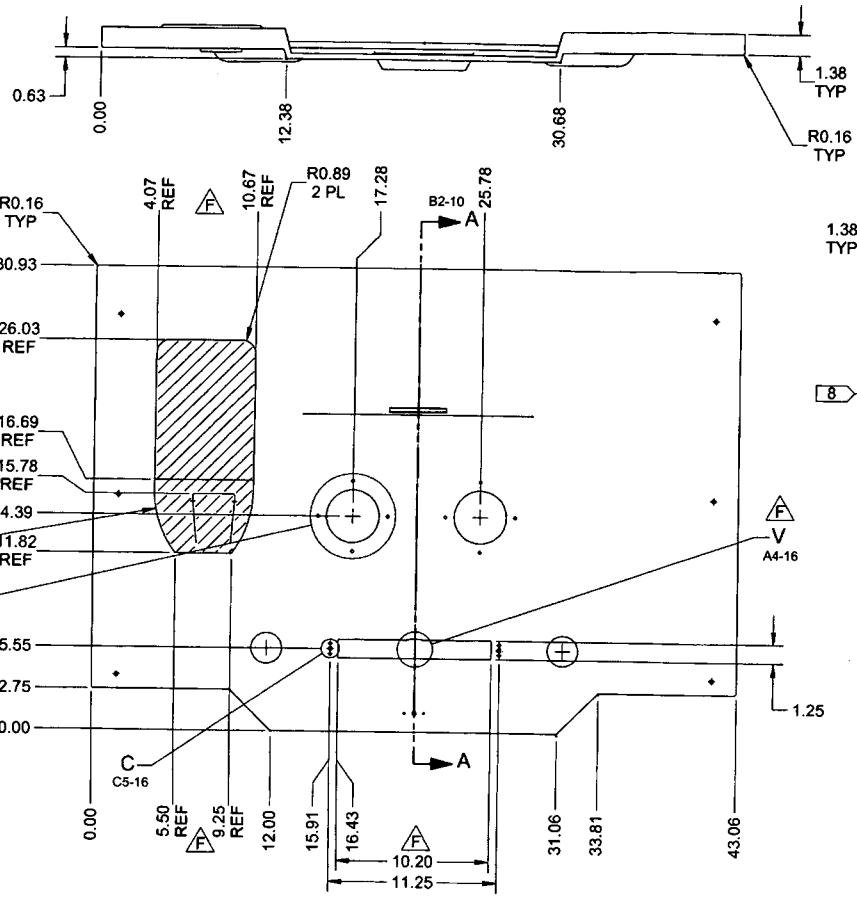
**Landing Gear**

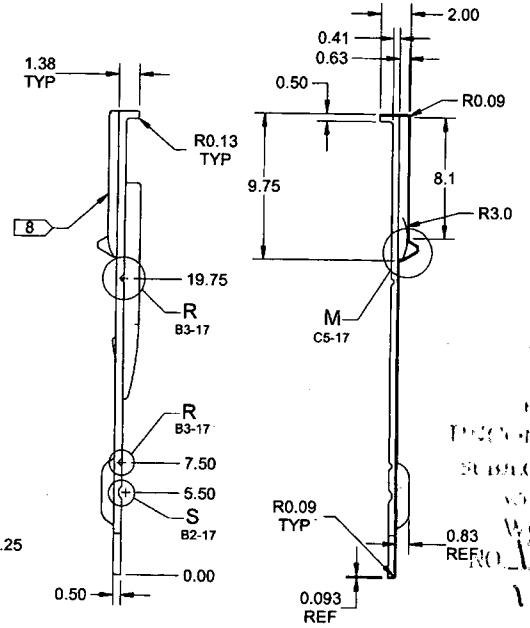
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☐ Centre Not Concentric
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☐ Crimp/Kink/Ripple/Wave
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____




**SECTION A-A** C6-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120780 MP
14-6-11

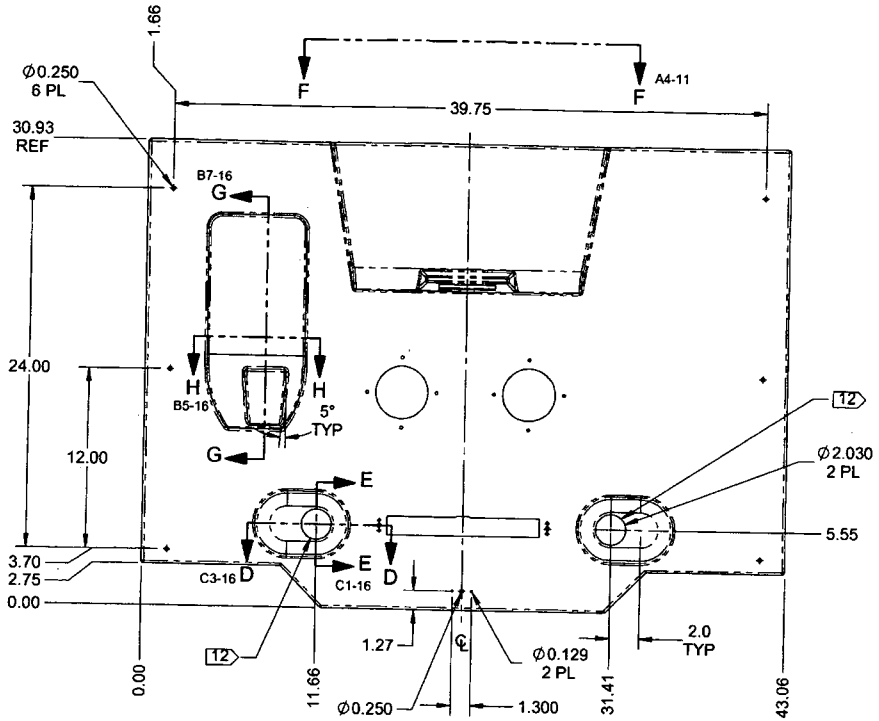
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

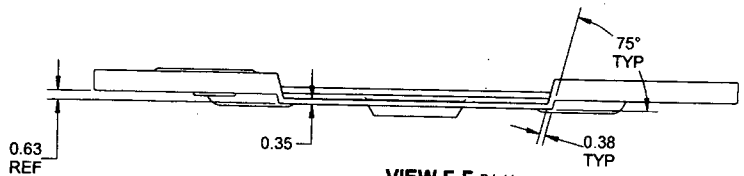
**D4634-1 FWD, CENTER CEILING PANEL**

**RELEASED**
2014 FEB 25

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | DC | DRAWING NO. D4634 REV. F |
| MFG. APPR. | | SHEET 10 OF 17 |
| APPROVED | | TITLE CENTER CEILING PANELS SCALE NTS |
| DE APPR. | | |
| DATE | 14.02.03 | |

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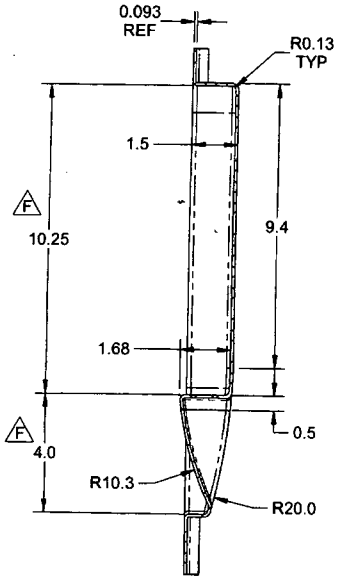

VIEW F-F D4-11

**D4634-1 FWD, CENTER CEILING PANEL**
AUXILIARY VIEW

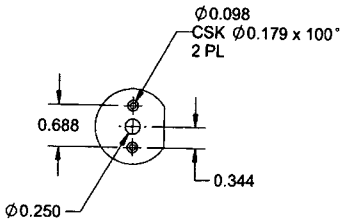
**RELEASED**
2014 FEB 25

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | DC | DRAWING NO. D4634 REV. F |
| MFG. APPR. | | SHEET 11 OF 17 |
| APPROVED | | TITLE CENTER CEILING PANELS SCALE NTS |
| DE APPR. | | |
| DATE 14.02.03 | | |

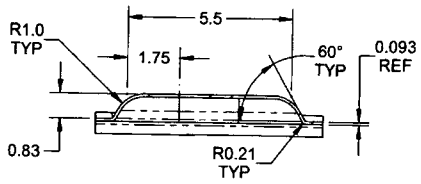
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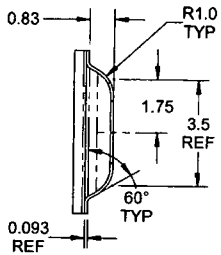

**SECTION G-G** C5-11
**SCALE 4X**



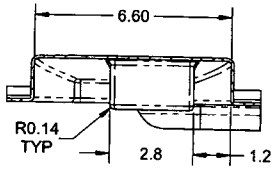

**DETAIL C** B7-10 B4-12 B4-14
**SCALE 4X**



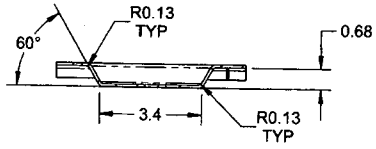

**SECTION D-D** B6-11 C4-13 C4-15
**SCALE 2X**



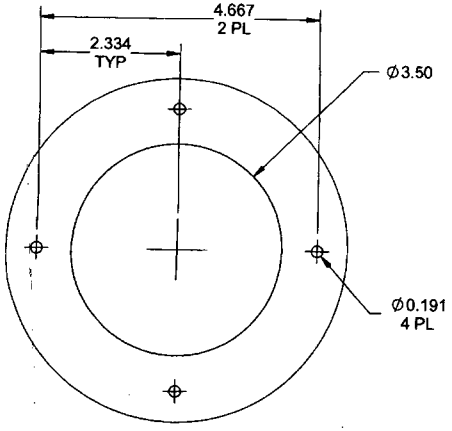

**SECTION E-E** B5-11 C4-13 C5-15
**SCALE 4X**



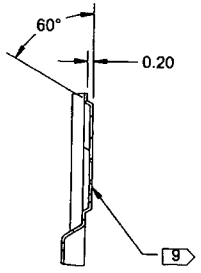

**SECTION H-H** C5-11
**SCALE 2X**



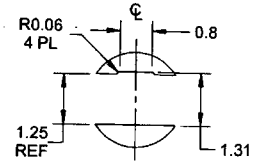

**SECTION J-J** B6-13
**SCALE 2X**




**DETAIL B** B7-10
**SCALE 4X**
**2 PL**




**DETAIL L** B2-13 C2-13 B2-14 C2-14
**SCALE 4X**
**TYP**

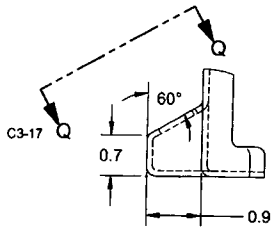



**DETAIL V** C4-10 B4-12 C4-14
**SCALE 2X**
**SIMILAR**

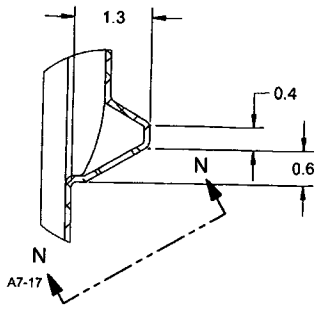
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| DRAWN | RF | DRAWING NO. REV. F |
| CHECKED | | D4634 SHEET 16 OF 17 |
| MFG. APPR. | | TITLE SCALE |
| APPROVED | | CENTER CEILING PANELS NTS |
| DE APPR. | | |
| DATE | 14.02.03 | |

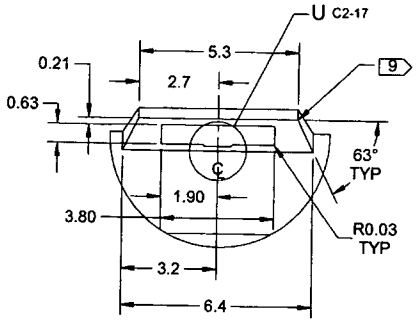
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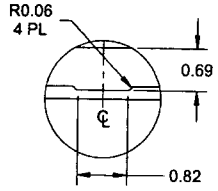

**DETAIL P** B3-14
**SCALE 2X**



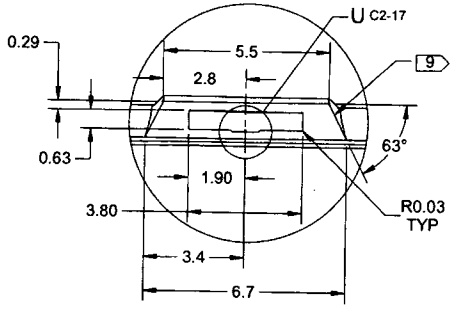

**DETAIL M** C3-10
**SCALE 2X**



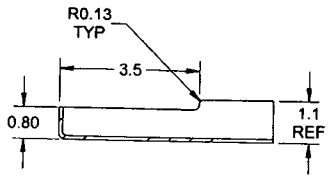

**DETAIL Q** B4-15 D8-17
**SCALE 0.5X**



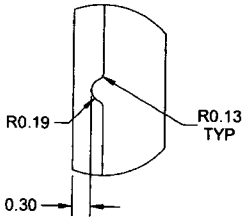

**DETAIL U** B7-17 D3-17
**SCALE 0.5X**



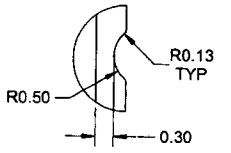

**DETAIL N** C5-17 B4-15
**SCALE 0.5X**



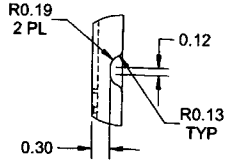

**SECTION O-O** B6-14
**SCALE 1.3X**




**DETAIL R** B3-10 C3-10 B2-12
**SCALE 4X**




**DETAIL S** B3-10 C2-12
**SCALE 4X**




**DETAIL T** C2-14
**SCALE 4X**

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# DART AEROSPACE LTD

| Description: Fwd Center Ceiling Panel | Work Order: |
|---|---|
| Inspection Drawing: 4634 Rev: F | Part Number: D4634-1 |

## INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 12.00 | +/-0.030 | 12.02 | ✓ | | SFAB 21 | |
| 24.00 | +/-0.030 | 24.00 | ✓ | | SFAB 21 | |
| 39.75 | +/-0.030 | 39.75 | ✓ | | " | |
| 11.66 | +/-0.030 | 11.66 | ✓ | | " | |
| 31.41 | +/-0.030 | 31.41 | ✓ | | " | |
| 1.300 | +/-0.010 | 1.302 | ✓ | | ~~set~~ TH-01 | |
| Ø0.250 | +0.005 -0.001 | .253 | ✓ | | TH 01 | |
| Ø2.030 | +0.002 -0.001 | 2.032 | ✓ | | TH 01 | |
| 4.667 | +/-0.010 | 4.661 | ✓ | | TH 01 | |
| 2.334 | +/-0.010 | 2.345 | ✓ | | TH 01 | |
| Ø3.50 | +/-0.010 | 3.506 | ✓ | | TH 01 | |
| Ø0.191 | +0.005 -0.001 | .191 | ✓ | | TH-01 | |
| 3.80 | +/-0.030 | 3.75 | ✓ | | TH 01 | |
| 0.63 | +/-0.030 | .65 | ✓ | | TH 01 | |
| 1.25 | +/-0.030 | 1.248 | ✓ | | TH 01 | |
| 10.20 | +/-0.030 | 10.20 | ✓ | | SFAB 21 | |
| 11.25 | +/-0.030 | 11.25 | ✓ | | " " | |
| .50 | +/- .030 | .521 | ✓ | | TH 01 | |
| 1.38 | +/- .030 | 1.382 | ✓ | | TH 01 | |
| .35 | +/- .030 | .382 | ✓ | | TH 01 | |
| ~~5.50~~ | ~~+/- .030~~ | | | | | |
| ~~7.50~~ | ~~+/- .030~~ | | | | | |
| ~~19.75~~ | ~~+/- .030~~ | | | | | |

| Measured by: | Checked By: DAS 27 9-89 | QC inspector: DAS 27 9-89 | Engineering Approval (*if necessary*): |
|---|---|---|---|
| Date 14/07/23 | Date 14/7/23 | Date 14/7/23 | Date |